

Work Order ID 68355

Tuesday, April 12, 2011 10:10:17 AM



Page 1

Item ID: D3794-1

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 4/12/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

11-04-12

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3794

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794 ☐ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-
Deburr if necessary

11-4-13

(26)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-4-13

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

m

11

04

13

(26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *FP-10* 0.00

Packaging

Memo

0.00

*26**BK 11-4-13.*

Packaging

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

u/h/14

Quality Control

*11-04-13**(26)*

W/O:		WORK ORDER CHANGES						
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Picklist Print

Page 1

Tuesday, April 12, 2011 10:10:23 AM

Work Order ID: 68355



Parent Item: D3794-1



Parent Item Name: Gasket

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063

Purchased

No

100

sf

438.7972

0.5902

10.49244

16.



4-1-13

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

438.7972

116832

38.7972

117295

400

117295

(26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	48355
Description: Gasket		Part Number:	D3794-1
Inspection Dwg: D3794 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.197	✓		U 1B02	
0.300 x 0.300	+/-0.010	303.365	x		V	
1.88	+/-0.030	1.889	✓		V	
0.90	+/-0.030	.905	✓		V	
3.90	+/-0.030	3.90	✓		T 1B01	
8.00	+/-0.030	8.00	✓		T	
14.00	+/-0.030	14.00	✓		T	
20.00	+/-0.030	20.00	✓		T	
14.07	+/-0.030	14.07	✓		T	
18.98	+/-0.030	18.98	✓		T	
23.90	+/-0.030	23.90	✓		T	
27.40	+/-0.030	27.40	✓		T	
29.40	+/-0.030	29.40	✓		T	
32.90	+/-0.030	32.90	✓		T	

Measured by: B	Audited by: M. M	Prototype Approval:	N/A
Date: 4-4-13	Date: 11-04-13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	

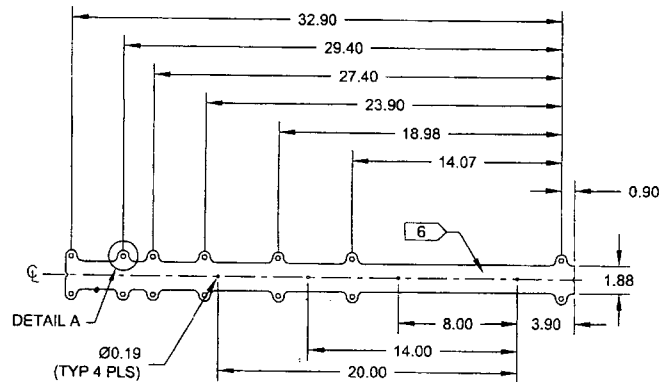
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

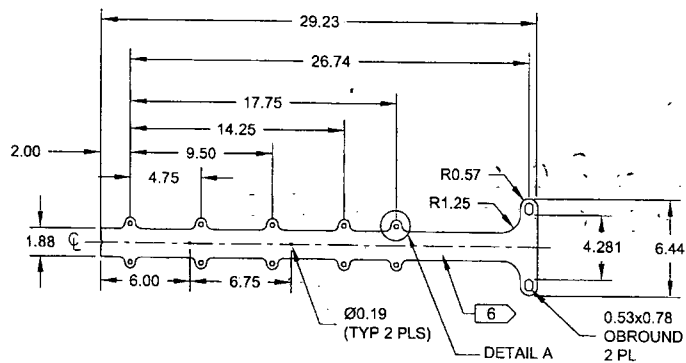
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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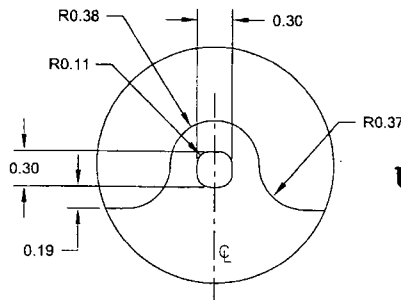
NOTE: Date & initial all entries



D3794-1 GASKET



D3794-3 GASKET



DETAIL A
SCALE 8X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68355

PH 11-04-12

RELEASED
08-05-13/14

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

REV.	NEW ISSUE	PH	08.05.14
DESIGN	PH	DESCRIPTION	BY DATE
DRAWN	PH	DART AEROSPACE USA, INC	
CHECKED		PORT HADLOCK, WA	
MFG. APPR.		DRAWING NO.	REV. A
APPROVED		D3794	SHEET 1 OF 1
DE APPR.		TITLE	SCALE
DATE	08.05.14	GASKET	NTS
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